Date: Wednesday, 2/6/2008 11:12:20 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: FLOOR PROTCTOR AFT RH
Job Number	: 37254		
Estimate Number	: 11235		
P.O. Number	:	**Part Number**	: D32814
This Issue	: 2/6/2008 **S.O. No.** :	**Drawing Number**	: D3281 REV ~~B~~ C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : THERMOFORMING	**Drawing Revision**	: ~~B~~ C
Previous Run	: 37111	**Material**	:
Written By	:	**Due Date**	: 2/18/2008 **Qty:** ~~10~~ 7 **Um:** Each
Checked & Approved By	: BB 08 02 06		
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM		
	Est Rev B 07.08.07 Thermoform in house DL		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	F6006 701	lexan black
	Comment: Qty.: 4.0000 sf(s)/Unit Total : 40.0000 sf(s) lexan black M 106995	
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
	Comment: HAND FINISHING THERMOFORMING 1) Cut Blanks BB 08/02/26	
3.0	THERMOFORMING	THERMOFORMING MACHINE
	Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D32811and Folio FTA 010 BB 08/02/26 X7 Dwg. Rev. C Folio Rev. B	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	BB 08/02/26 X7	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
	Comment: HAND FINISHING THERMOFORMING BB 08/02/27 X1 1) Trim to Finished Dimensions BB 08/02/27 X6	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** DD **Date:** 08/03/07

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 2/6/2008 11:12:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** FLOOR PROTCTOR AFT RH

Job Number: 37254 **Part Number:** D32814

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc. BB 08/02/26 KT

2) Check dimensions to ensure conformity to drawing tolerances.

7.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 08/03/03

8.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1 ST 2060 08/03/04 KT

9.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 08/03/04

Job Completion

08-03-04

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37254
Description:	Part Number:	D3281-4
Inspection Dwg: Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 3/16 "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 08/02/27

TRIMMING SECTION

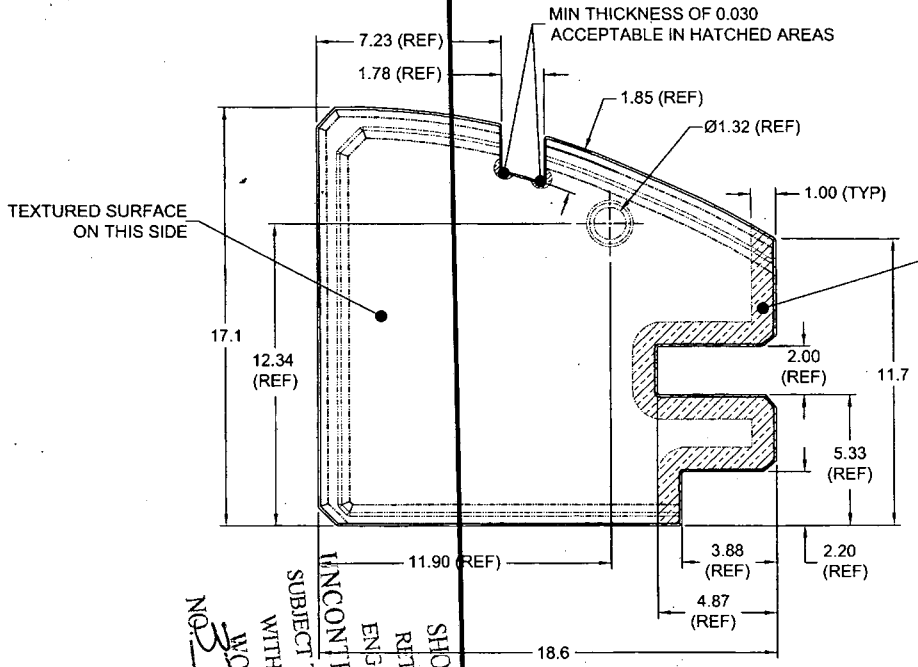
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.95	.030	.974	✓			
.25	.030					
17.1	.100	17.12	✓			
14.3	.100	14.3	✓			

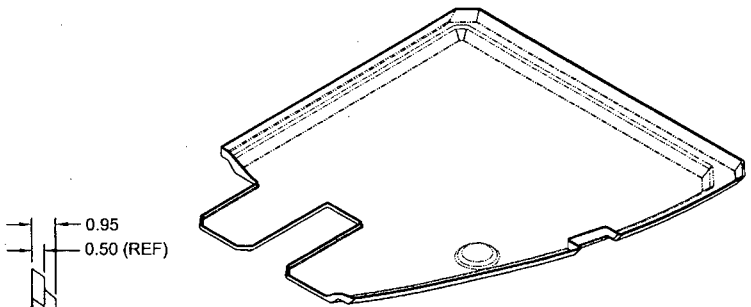
Measured by: BR Date: 08/02/07

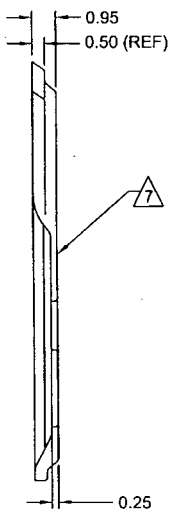
Audited by: Date: 08/03/03

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	







D3281-1 FLOOR PROTECTOR

RELEASED
07.11.06

WORK ORDER
NO. 31257

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WITHOUT NOTICE

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D3281-1 NOTES:

1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
   MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
   (REF DART SPEC MLEXS.125-F6006-02)
3) FINISH: NONE
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.010 MAX
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
8) WEIGHT: 1 lb

REV.	DESCRIPTION	BY	DATE
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3281	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	07.10.09		

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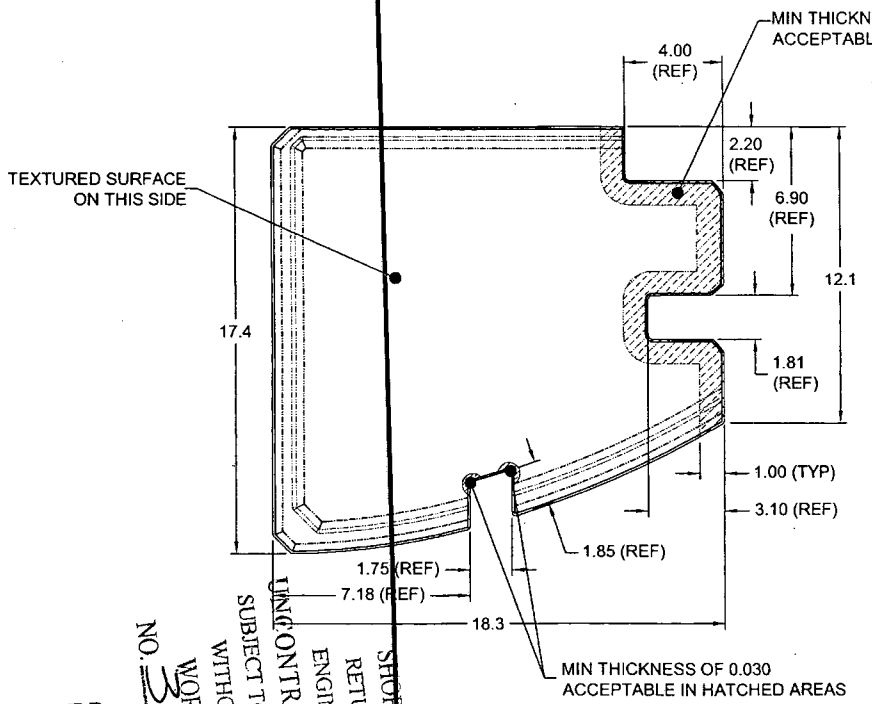

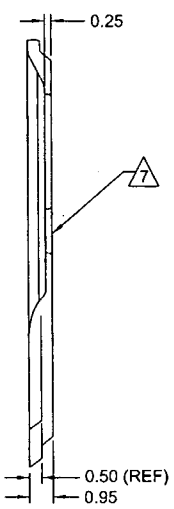

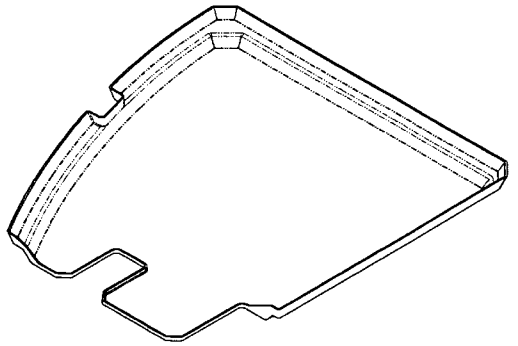

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NO. 37254

D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
   MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
   (REF DART SPEC MLEXS.125-F6006-02)
3) FINISH: NONE
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.010 MAX
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
8) WEIGHT: 1 lb

DESIGN		**DART AEROSPACE LTD**	
DRAWN		**HAWKESBURY, ONTARIO, CANADA**	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3281	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	07.10.09		

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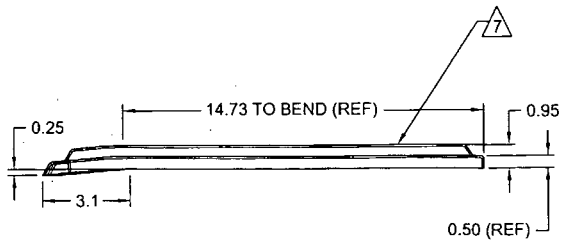

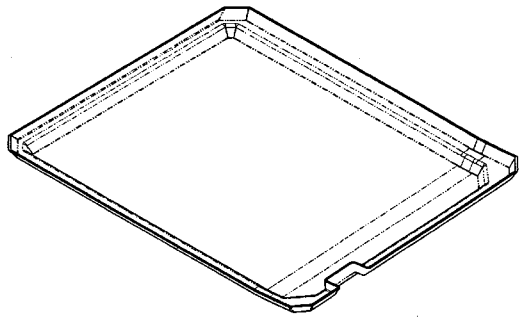

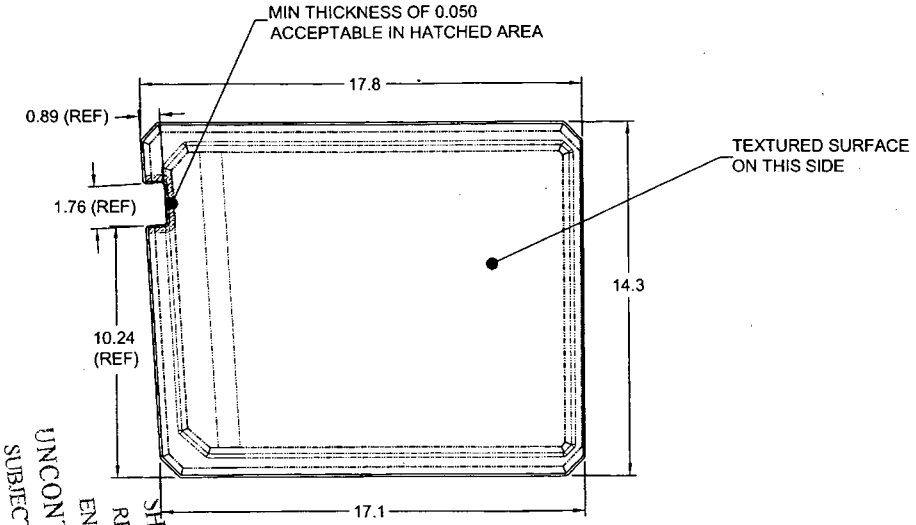

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D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)

D3281-3/-4 NOTES:

1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
   MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
   (REF DART SPEC MLEXS.125-F6006-02)
3) FINISH: NONE
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.010 MAX
7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
8) WEIGHT: 1 lb

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	LE	
CHECKED	PH	DRAWING NO. D3281 REV. C
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE FLOOR PROTECTOR SCALE NTS
DE APPR.		
DATE 07.10.09		

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